

Date: Monday, 13/04/2009 8:22:38 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SUPPORT
Job Number :	47120		
Estimate Number :	12487		
P.O. Number :		Part Number :	D35021
This Issue :	13/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3502 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	42968	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	30/04/2009
Written By :		Qty :	24
Checked & Approved By :	<u>JL 09/04/23</u>	Um :	Each
Comment :	Est Rev:A New Issue 06-07-06 JLM Est Rev:B Add tooling hole 07-03-28 Est rev C added DT9430 08.11.03 EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X04000	6061-T6 Bar 1.00 x 4.00
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Comment: Qty.: 0.3035 f(s)/Unit Total: 7.2828 f(s)

6061-T6 Bar 1.0" x 4.0" *not in computer*
 batch: M8803

JL 09/04/23

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 3.475" long
 1 BLANK MAKES 2 PARTS

JL 09/04/23

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: B & Dwg D3502 Rev: B

(23)

(P10)

2-Deburr per dwg D3502

mmf 09/04/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(23)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3502-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47120</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/27	30	Tool mark in jis made a groove in piece RL tooling	CP 06.04.27 pu QSI 042	1 scrap no replace Rix Sij (remove mark)	mmf 07/04/27	S 07/04/27	CP 06.04.27 pu QSI 042	S 07/04/27
09-04-28	6	Tool Hole drilled on wrong side	B 09-04-28	acceptable	RB 09-04-28	RB 09-04-28	RB 09-04-28	RB 09-04-28

NOTE: Date & initial all entries

Date: Monday, 13/04/2009 8:22:38 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 47120

Part Number: D35021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 09/04/27

23

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Mark hole position using DT9430

Drill as per Dwg D3502.

09/04/28

23

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

09-04-29

23

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

14:10

OVEN TEMPERATURE:

320°

FINISH TIME:

14:40

mid/BL

09/04/29

23

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-30

23

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 108

09/04/30

23

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

23

Job Completion



mf 09-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

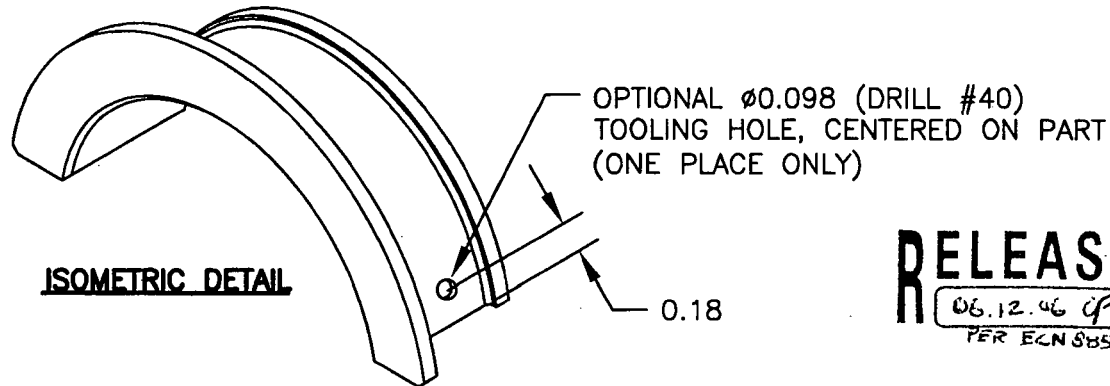
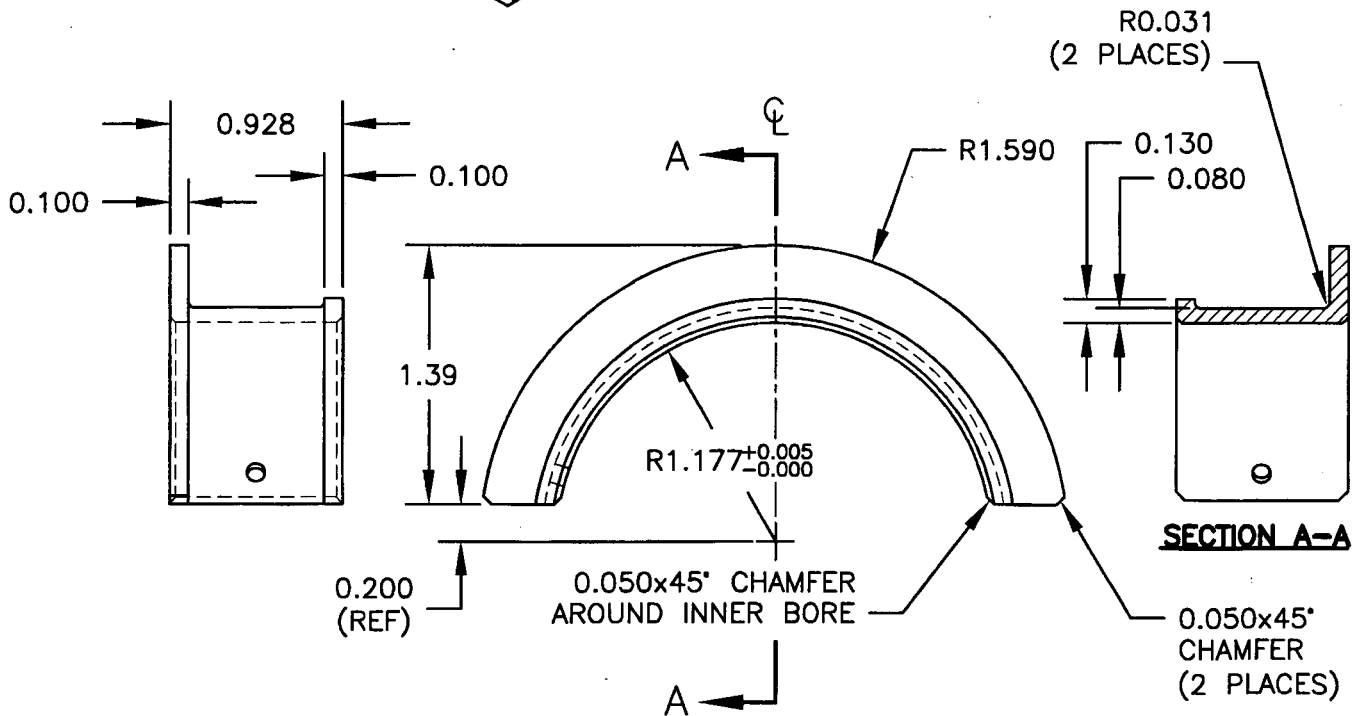
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	

**RELEASED**
06.12.06 qp
PER ECN 885**D3502-1 SUPPORT**

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
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UNLESS NOTICED
WORK ORDER
NO. 47120

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